



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-3700-C-09
Job Sheet 189607



Part No: RBE350A94-3700-C-09

Job Qty: 10 pcs

DAS

21

9-88

Part Name: Knurled Nut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/29/19

Job Tracking No:

Due Date: 2/11/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A94-3700-C Rev 6 IPP Rev A 18.01.15 New issue DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
120	NLX 2500SY - 1	10 pcs	2/11/19	2/11/19	0.00	5.00	NLX 2500SY - 1	
130	QC 2	10 pcs	2/11/19	2/11/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 38	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S162849



Part: RBE350A94 - 3700 - C - 09

Job No: 189607

Serial No/Batch: S162849

Revision: 6

Inspector:

Exp Date:

Instructions:

Date: 03/15/19

140	QC 8	10 pcs	2/11/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 38	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	B.P. 19-03-15
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
150	Outsource - 12 - Black Oxide	10 pcs	2/11/19		GRO002-VC	5 03/10/2019 PL
160	Packaging 2-1 - Receive - B4B	10 pcs 15 pcs	2/11/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	DP MAR 26 2019
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
170	QC 6	10 pcs	2/11/19	0.00 0.00	QC 6 - 38	

					QC 6 - 42		DAS
					QC 6 - 9	MAR 27 2019	40
					QC 6 - 68		9-89
					QC 6 - 61		9-89
180	Packaging 3-1 - Stock - B4B	10 pcs	2/11/19	0.00 0.00	Packaging 3 - 1 - B4B		
					Packaging 3 - 2 - B4B		
					Packaging 3 - 3 - B4B		
					Packaging 3 - 4 - B4B		
					Packaging 3 - 5 - B4B		
					Packaging 3 - 6 - B4B		
					Packaging 3 - 7 - B4B		DAS
					Packaging 3 - 8 - B4B		20
					Packaging 3 - 9 - B4B		9-89
					Packaging 3 - 10 - B4B		
					Packaging 3 - 11 - B4B		
					Packaging 3 - 12 - B4B		
					Packaging 3 - 13 - B4B		
					Packaging 3 - 14 - B4B		
					Packaging 3 - 15 - B4B		
					Packaging 3 - 16 - B4B		
					Packaging 3 - 17 - B4B		
					Packaging 3 - 18 - B4B		
					Packaging 3 - 19 - B4B		
					Packaging 3 - 20 - B4B		
					Packaging 3 - 21 - B4B		
					Packaging 3 - 22 - B4B		
					Packaging 3 - 23 - B4B		
					Packaging 3 - 24 - B4B		
					Packaging 3 - 25 - B4B		
					Packaging 3 - 26 - B4B		
					Packaging 3 - 27 - B4B		
					Packaging 3 - 28 - B4B		
					Packaging 3 - 29 - B4B		
					Packaging 3 - 30 - B4B		
					Packaging 3 - 31 - B4B		
					Packaging 3 - 32 - B4B		
					Packaging 3 - 33 - B4B		
					Packaging 3 - 34 - B4B		
					Packaging 3 - 35 - B4B		
					Packaging 3 - 36 - B4B		
190	QC 21 - SA	10 pcs	2/11/19	0.00 0.00	QC 21 - SA - 21	DAS	MAR 28 2019
					QC 21 - SA - 70	21	

Part Op 120 - (MORI NLX 2500SY LATHE) , 1-Machine as per folio FB778 FOLIO REV: AA DWG REV: 6
 Descriptions: 2-Debur

130 - (QC2- Inspect parts off machine FAI/FAIB)

140 - (QC8- Inspect parts - second check)

150 - -Issue P/O; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

160 - (Receive & Inspect for Damage & Mat'l Certs)

170 - (QC6- All purchased or subcontracted products)

180 - (Identify as per dwg & Stock Location:)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-1144-R1.375	AISI 1144 Stressproof Round Bar 1.375"	.5000 ft (.05 ea)	120-NLX 2500SY - 1	S037968

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-NLX 2500SY - 1	MT-1144-R1.375	1	12	0

Part Specifications

Specifications could not be found.

Plex 1/29/19 7:33 AM Dart.lajeunesse.marie

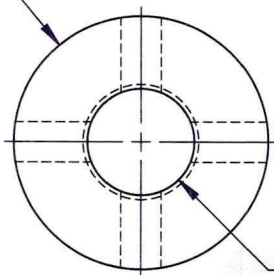
This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6	16-0286	-09 CH'D DIM WAS .20 IS 2X .20, ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D.	2/28/2017	RJC	SM

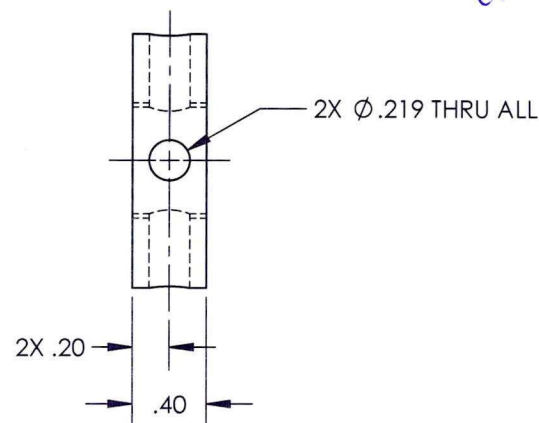
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189607 MJS
19-01-29



Ø 1.38
MED. KNURL



5/8-18 UNF - 2B
THRU ALL



(-09)

KNURLED NUT

DART AEROSPACE	
TITLE SWASHPLATE IMMOBILIZING TOOL ADJUSTABLE BRACE	
DWG NO. RBE350A94-3700-C-09	REV 6
MAT'L STRESS PROOF	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: MACKOVJAK	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 8/21/2012
	SHEET 7 OF 7

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER

PO042910



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042910

PO Date: 3/18/19

Due Date: 3/25/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189607	RBE350A94-3700-C-09	Knurled Nut -Issue P/O; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed -		3/25/19	15 pcs	0 pcs	15 pcs	\$6.00/pcs	\$90.00
Line Item Note ** need back March 25,2019 **											
2	188399	RBT18021	Extension Tool Main Transmission Corner Mount -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed -		3/25/19	3 pcs	0 pcs	3 pcs	\$6.00/pcs	\$18.00

Line Item Note ** NEED BACK MARCH 25,2019 **



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PURCHASE ORDER

PO042910



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	189483	RBEVR-L11-0010-002-B-1	Rod Weldment -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	3/25/19	2 pcs	0 pcs	2 pcs	\$6.00/pcs	\$12.00

Line Item Note ** NEED BACK MARCH 25,2019 **

Grand Total: \$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/19/19 11:32 AM dart.Lussier.Patrick



Certificat de Conformité / Certificate of Compliance

(017762-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

017762- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
25-Mar-2019		Jessie Boisvert		PO042910				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A94-3700-C-09 Rev.	RBE350A94-3700-C-09 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	15	15	0	0	DAS 40 9-89 0
2	RBT18021 Rev.	RBT18021 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL AFTER WIPE OFF EXCESS OIL	OXIDE-BLACK CH	3	3	0	0	
3	RBEVR-L11-0010-002-B-1 Rev.	RBEVR-L11-0010-002-B-1 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL AFTER WIPE OFF EXCESS OIL	OXIDE-BLACK CH	4	4	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.